

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008686**Date Inspected:** 21-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Lv Li Qing / Shen Fu You**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Tim McClendon was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG Bay No. 14

During random verification Magnetic Particle Testing (MT) of repair area on drilled holes ref. B-CWR636 for OBG Floor Beam FB020-005 (FL3) on 10CE, Caltrans Quality Assurance (QA) Inspector discovered one (1) linear indication after ZPMC performed MT inspection. The QA inspector was only notified after the drilling operation was completed; the QA should have been notified as per the requirements of B-CWR636. See photographs for additional information. An incident report will be written on this issue.

Flux Cored Arc Welding (FCAW) on Floor Beam FL 1 to FL 2-2 Complete Joint Penetration weld of weld joint SEG 054 SSD 020 PP 77 for OBG weld number 135 for Segment 9CE. The ZPMC welder identified as 055491 was welding in the 3G position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Flux Cored Arc Welding (FCAW) on Floor Beam FL 1 to FL 2-2 Complete Joint Penetration weld of weld joint SEG 054 SSD 020A PP 77 for OBG weld number 131 for Segment 9CE. The ZPMC welder identified as 044795

WELDING INSPECTION REPORT

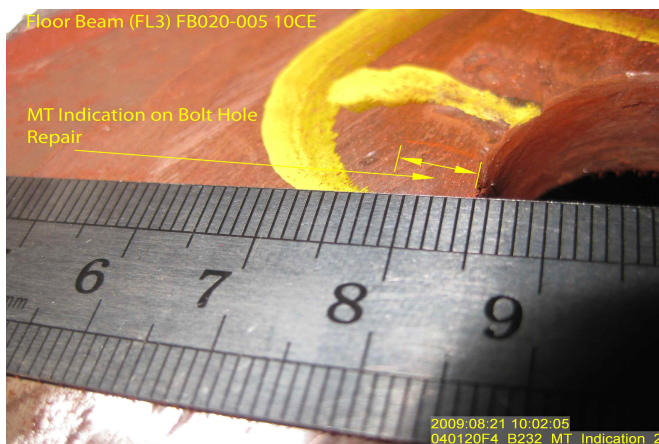
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Flux Cored Arc Welding (FCAW) on Floor Beam FL 1 to FL 2-2 Complete Joint Penetration weld of weld joint SEG 054 SSD 019 PP 77 for OBG weld number 135 for Segment 9CE. The ZPMC welder identified as 055491 was welding in the 3G position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-B-U2-F.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations spoken on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By: McClendon, Timothy

Quality Assurance Inspector

Reviewed By: Patterson, Rodney

QA Reviewer